

Work Order ID 76940

November-24-11 11:19:02 AM

ASAP

76940

Page 1

Item ID: D3500-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle

Start Date: 24/11/2011 Start Qty: 30.00

30

Cust Item ID:

Required Date: 01/12/2011 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3500	C								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 376940 Double check by: 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine
Step No 3 per Folio FA641 and inspect p

OK 12/03/12
D.A 12/03/20

30 0

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 12/03/12
D.A 12/03/20

30 0

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

OK 12/3/22

30 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76940

November-24-11 11:19:02 AM

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Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 24/11/2011 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 01/12/2011 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11h25 FINISH TIME: 11h55 OVEN TEMPERATURE: 320°F								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

30 BL 123-26

30 Q (SP) 12/03/26

m120222

30 BL 123-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76940

76940

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November-24-11 11:19:02 AM

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 24/11/2011 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 01/12/2011 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <u>425</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

ML5 12/03/27
 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-24-11 11:19:08 AM

Page 1

Work Order ID: 76940

76940

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 24/11/2011

Required Date: 01/12/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	68.0000	1	30			

D6102-013

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT042	24	
76001	24	
MAT043	44	
59467	3	
60713	8	
61300	1	
70674	12	
73492	20	

77781 x 30

OK 12/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76940
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.589	1.588	1.588		
J	0.240	0.260		.247	.245	.247	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.259	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.996	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.541	.551	.551	.551		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.058	.047	.050	.050		
Y	0.100	0.120		.108	.107	.108	.108		
AA	R1.125	R1.145		1.135	1.135	1.134	1.133		
AB	R.490	R.510		R.500	R.500	R.500	R.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.251	.250	.251	.253		
AE	1.810	1.830		1.823	1.821	1.821	1.820		
AF	0.240	0.260		.253	.251	.252	.251		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.147	.149	.149	.149		
AI	0.140	0.160		.159	.153	.154	.155		
Accept/Reject									

Measured by:	amk
Date:	12/03/18

Audited by:	SA
Date:	12/3/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76940
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.588	1.587	1.588		
J	0.240	0.260		.246	.246	.245	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.551	.550	.551		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.106	.110	.110	.100		
AA	R1.125	R1.145		1.134	1.133	1.134	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.257	.257	.257	.257		
AE	1.810	1.830		1.820	1.819	1.819	1.820		
AF	0.240	0.260		.252	.250	.257	.257		
AG	0.140	0.160		.150	.149	.150	.149		
AH	0.140	0.160		.151	.149	.149	.149		
AI	0.140	0.160		.153	.154	.153	.155		
Accept/Reject									

Measured by:	mf
Date:	12/03/18

Audited by:	[Signature]
Date:	2/3/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	[Signature]

DART AEROSPACE LTD		Work Order: 76940
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/1	2/10	3/11	4/12	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.585	1.588	1.588		
J	0.240	0.260		.246	.248	.246	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.550	.550	.551		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		R.250	R.250	R.250	R.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.106	0.106	0.106	0.106		
AA	R1.125	R1.145		1.133	1.130	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.252	.253	.251	.251		
AE	1.810	1.830		1.818	1.818	1.819	1.818		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.148	.149	.149	.149		
AH	0.140	0.160		.152	.153	.152	.153		
AI	0.140	0.160		.153	.154	.153	.153		
Accept/Reject									

Measured by:	mr
Date:	12/03/18

Audited by:	SA
Date:	12/3/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order: 76940
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	2/4	3/5	4/6	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.591	1.590	1.589	1.589		
J	0.240	0.260		.244	.245	.244	.244		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.551		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		R.250	.250	.250	.250		
X	0.040	0.060		.055	.050	.050	.050		
Y	0.100	0.120		.108	.105	.108	.108		
AA	R1.125	R1.145		1.135	1.135	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.251	.250	.251	.249		
AE	1.810	1.830		1.820	1.820	1.819	1.819		
AF	0.240	0.260		.251	.250	.250	.249		
AG	0.140	0.160		.151	.150	.150	.149		
AH	0.140	0.160		.151	.152	.152	.151		
AI	0.140	0.160		.153	.154	.152	.153		
Accept/Reject									

Measured by:	aml
Date:	12/03/19

Audited by:	SA
Date:	12/3/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order: 76940
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/7	2/8	3/9	4/20	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.589	1.589	1.589		
J	0.240	0.260		.245	.244	.245	.244		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.050	.050	.050		
Y	0.100	0.120		.110	.108	.108	.108		
AA	R1.125	R1.145		1.134	1.134	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.251	.252	.251	.250		
AE	1.810	1.830		1.819	1.820	1.819	1.819		
AF	0.240	0.260		.250	.251	.250	.250		
AG	0.140	0.160		.150	.150	.150	.149		
AH	0.140	0.160		.152	.153	.152	.152		
AI	0.140	0.160		.153	.155	.152	.153		
Accept/Reject									

Measured by:	OMK
Date:	12/03/19

Audited by:	SA
Date:	12/3/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order: 76940
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.587	1.588	1.589		
J	0.240	0.260		.246	.246	0.248	0.247		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	0.550	0.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	0.050	0.050		
Y	0.100	0.120		.108	.108	0.108	0.108		
AA	R1.125	R1.145		1.134	1.131	1.136	1.136		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.253	.253	0.255	0.255		
AE	1.810	1.830		1.819	1.819	1.819	1.819		
AF	0.240	0.260		.250	.250	0.253	0.253		
AG	0.140	0.160		.150	.149	.149	.149		
AH	0.140	0.160		.153	.153	0.152	0.152		
AI	0.140	0.160		.154	.154	0.155	0.154		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	12/03/19

Audited by:	<i>[Signature]</i>
Date:	12/3/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 76940
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	125	26	327	128	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.591	1.589	1.590		
J	0.240	0.260		0.250	0.250	0.251	0.250		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.550	0.550	0.550	0.550		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.136	1.136	1.136	1.137		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.255	0.255	0.255	0.255		
AE	1.810	1.830		1.819	1.821	1.821	1.821		
AF	0.240	0.260		0.252	0.251	0.252	0.251		
AG	0.140	0.160		0.152	0.152	0.152	0.152		
AH	0.140	0.160		0.153	0.154	0.153	0.153		
AI	0.140	0.160		0.146	0.147	0.146	0.147		
Accept/Reject									

Measured by: D.A
Date: 12/03/20

Audited by: [Signature]
Date: 12/3/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ [Signature]	[Signature]

DART AEROSPACE LTD		Work Order: 76940	
Description: Saddle		Part Number: D3500-1	
Inspection Dwg: D3500		Rev: C	
		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	129	230	3	4	By	Date
A	0.483	0.490		0.486	0.486				
B	1.175	1.185		1.180	1.180				
C	3.145	3.155		3.150	3.150				
D	1.175	1.185		1.180	1.180				
E	0.365	0.385		0.375	0.375				
F	0.490	0.510		0.500	0.500				
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.586				
J	0.240	0.260		0.250	0.251				
K	0.490	0.510		0.500	0.500				
L	3.590	3.650		3.620	3.620				
M	0.315	0.322		0.316	0.316				
N	0.256	0.262		0.258	0.258				
O	6.500	6.520		6.510	6.510				
P	5.990	6.010		6.000	6.000				
Q	2.820	2.830		2.825	2.825				
R	2.495	2.505		2.500	2.500				
S	2.245	2.255		2.250	2.250				
T	1.120	1.130		1.125	1.125				
U	0.540	0.560		0.550	0.550				
V	0.793	0.803		0.798	0.798				
W	R.240	R.260		0.250	0.250				
X	0.040	0.060		0.050	0.050				
Y	0.100	0.120		0.105	0.105				
AA	R1.125	R1.145		1.137	1.137				
AB	R.490	R.510		0.500	0.500				
AC	0.615	0.635		0.630	0.630				
AD	0.240	0.260		0.255	0.254				
AE	1.810	1.830		1.827	1.827				
AF	0.240	0.260		0.252	0.252				
AG	0.140	0.160		0.152	0.152				
AH	0.140	0.160		0.155	0.155				
AI	0.140	0.160		0.148	0.147				
Accept/Reject									

Measured by:	B.A
Date:	12/03/20

Audited by:	SA
Date:	12/3/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

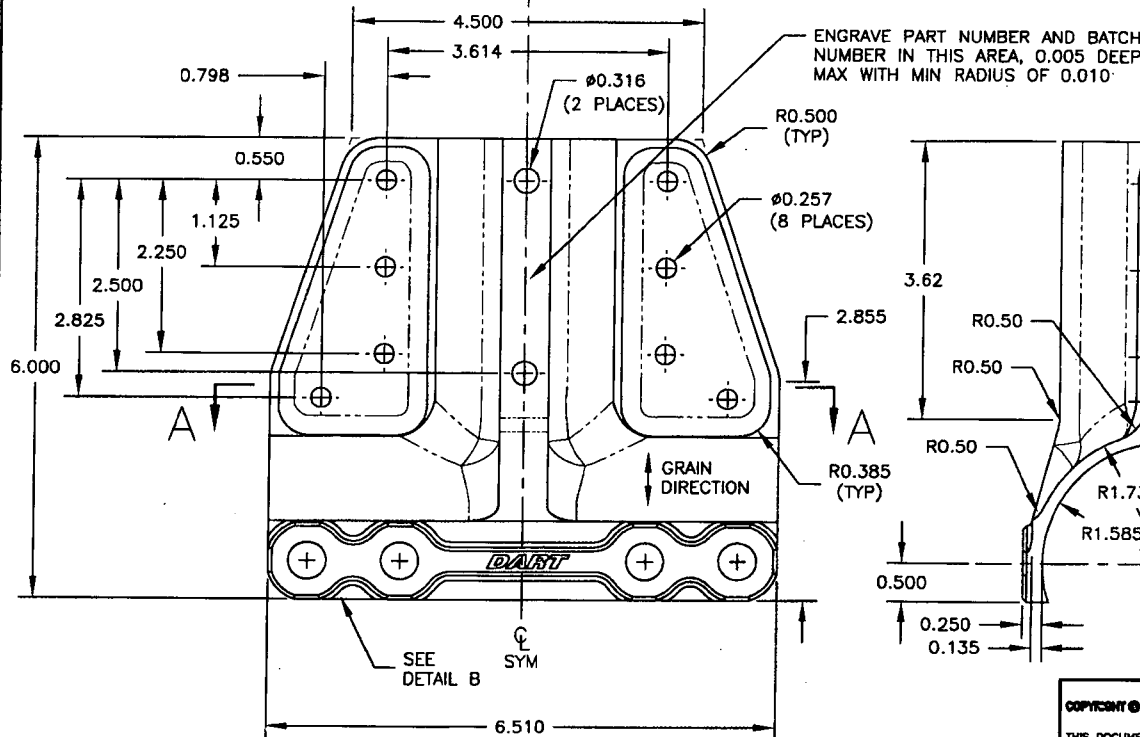
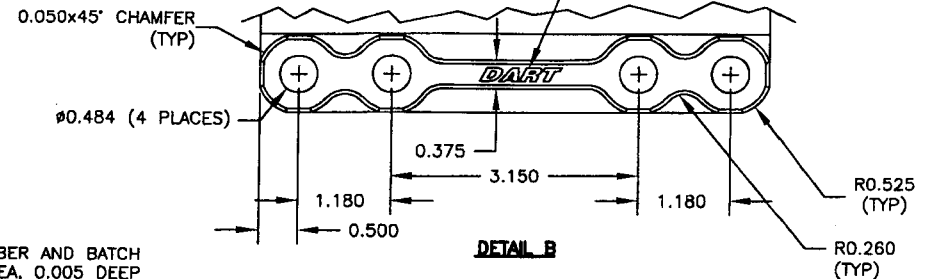
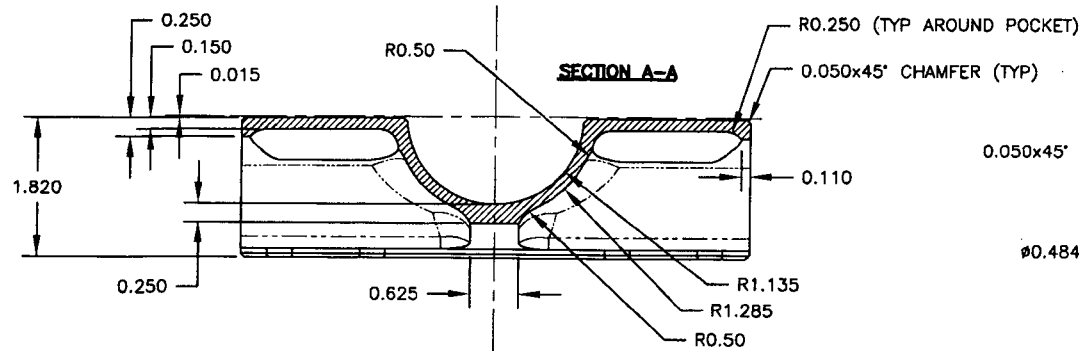
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 36940 M.C.J
11/1/24

ENGRAVE DART LOGO IN
THIS AREA TO A MAX
DEPTH OF 0.015 AND A MIN.
TOOL RADIUS OF 0.250



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DART
CHECKED	PH	DART
DATE	06.06.30	SADDLE
DRAWING NO.	D3500	REV. C
TITLE	SADDLE	SHEET 1 OF 1
		SCALE
		2:3

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DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries